

Work Order ID 53156

October 23, 2009 10:55:01 AM



Page 1

Item ID: D3983-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Inner Closeout

Start Date: 23/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PS*

Date: *9-10-23*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3983

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3983

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

0.00

HB 9-10-28

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

HB 9-10-28

EP 09/10/28

(10)

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October 23, 2009 10:55:01 AM



Page 2

Item ID: D3983-3

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Setup Start



Revision ID: A

Stop



Item Name: Inner Closeout

Start Date: 23/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



2> 509/10/29

(10)

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



bf 09-10-29

(10)

HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00



91 09/10/29

(X10) 0

QC

Memo

0.00

Quality Control

Work Order ID 53156

October 23, 2009 10:55:01 AM



Page 3

Item ID: D3983-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Inner Closeout

Start Date: 23/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/10/09 900 SL

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/02 JF

MF
09-10-30

Picklist Print

October 23, 2009 10:55:08 AM

Page 1

Work Order ID: 53156



Parent Item: D3983-3



Parent Item Name: Inner Closeout

Start Date: 23/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	90.3986	0.6105			
6061-T6 .040 Sheet												



18 9-10-09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

90.3986

100742

3.3

102723

5.93

105842

12

106747

5.7516

107461

11.7841

109396

22.28

111224

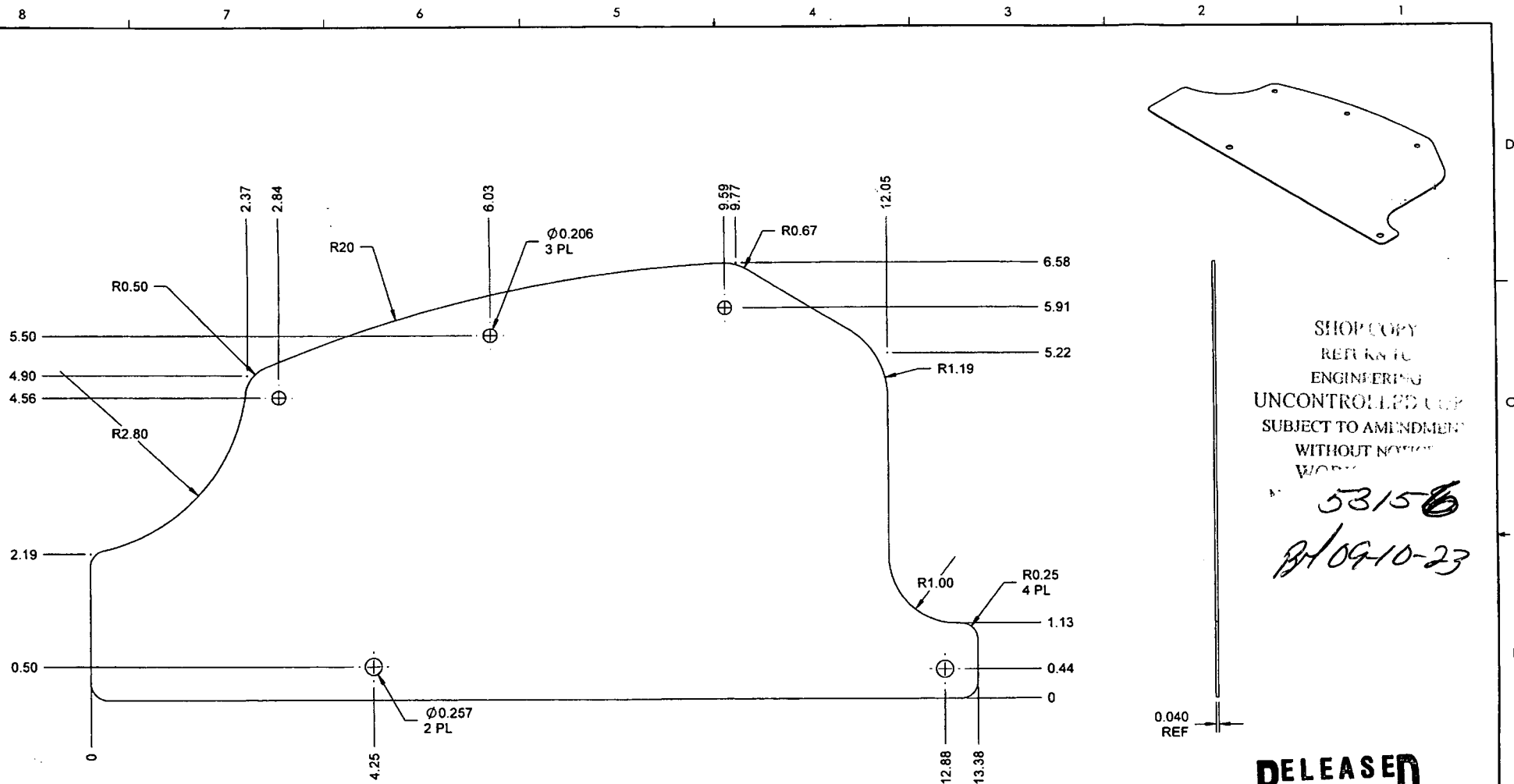
27.8529

19380

1.5

113004

113004



D3983-1 OUTER CLOSEOUT

SHOP COPY
REF KATC
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK

53156
B/09-10-23

RELEASED
2009-10-13

NOTES:
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-1" AND B/N USING FINE POINT PERMANENT INK MARKER
WEIGHT: 0.26 lbs

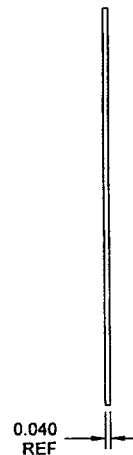
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		09.09.09
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.09.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3983** REV. A
SHEET 1 OF 7

TITLE **CLOSE OUT KIT** SCALE NTS

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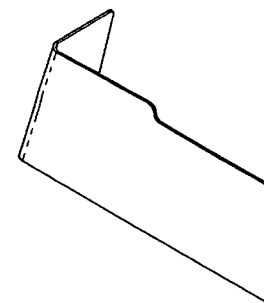
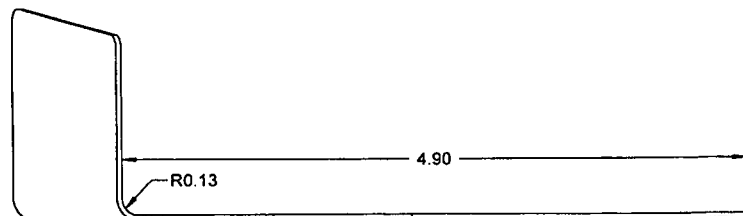


W/058156

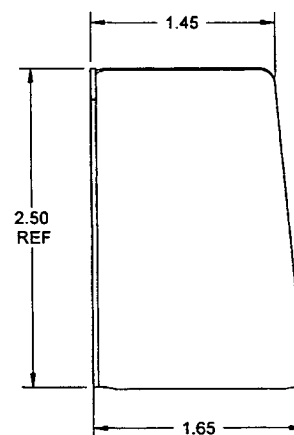
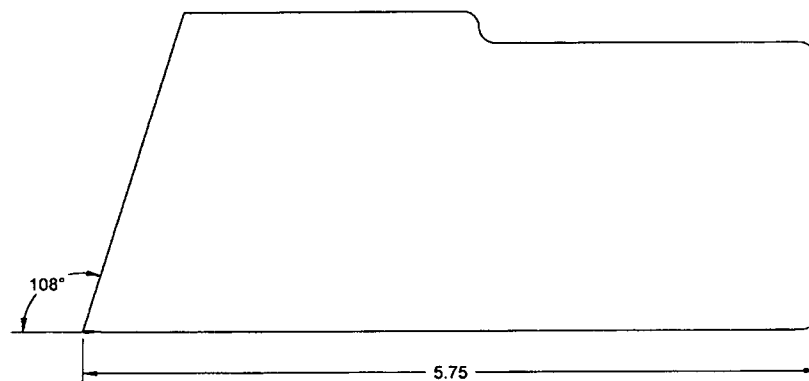
.094

RELEASE
2009-10-13

DESIGN	<i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3983 TITLE CLOSE OUT KIT COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. A
DRAWN	<i>JS</i>		SHEET 2 OF 2
CHECKED	<i>JS</i>		SCALE
MFG. APPR.	<i>JS</i>		NTS
APPROVED	<i>JS</i>		
DE APPR.	<i>JS</i>		
DATE	09.09.09		



w/053156

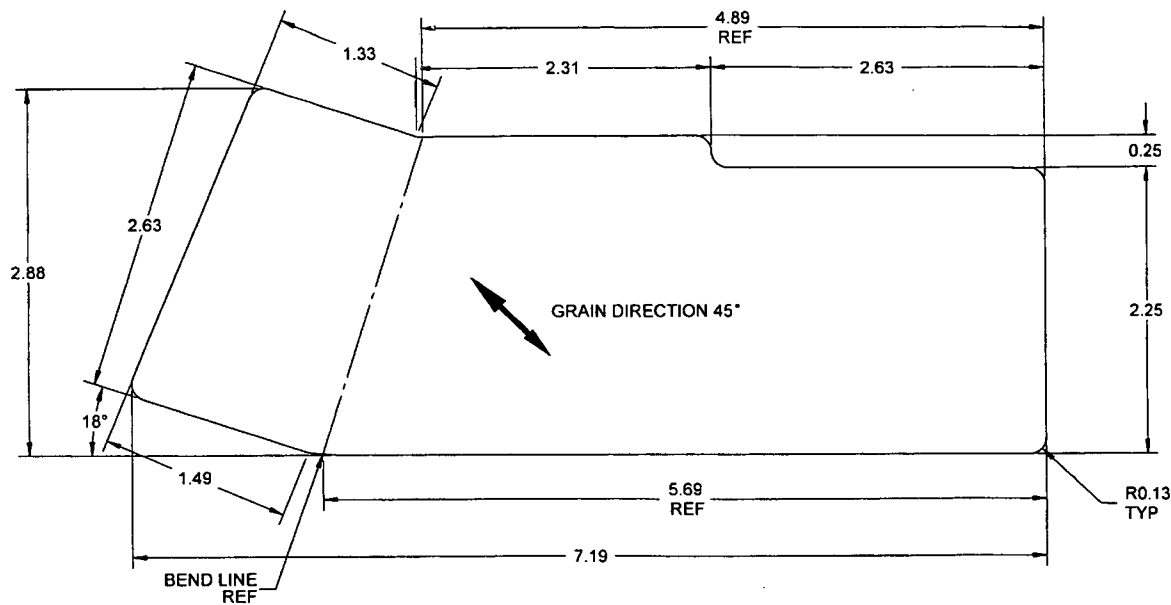


D3983-5 HINGE CLOSEOUT
(MADE FROM D3983-5F)

RELEASED
2009-10-13

NOTES:
MATERIAL: D3983-5F
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-5" AND B/N USING FINE POINT PERMANENT INK MARKER
WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 3 OF 7
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W/O 53154

D3983-5F HINGE CLOSEOUT FLAT PATTERN

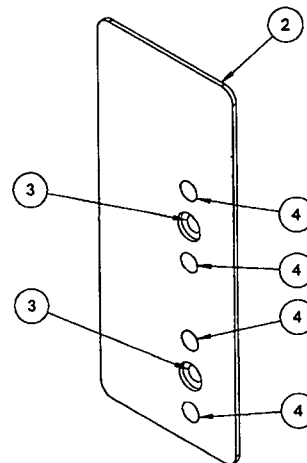
RELEASED
2009-10-13
MP

NOTES:
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040

FINISH: N/A
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 0.06 lbs

DESIGN	45	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	45		
CHECKED	45	DRAWING NO.	REV. A
MFG. APPR.	45	D3983	SHEET 4 OF 7
APPROVED	45	TITLE	SCALE
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ITEM	QTY. -047	PART NUMBER	DESCRIPTION
1	X	D3983-047	CLOSEOUT ATTACHMENT
2	1	D3983-7	PLATE
3	2	MS21059L3	ANCHOR NUT
4	4	MS20426AD3-4	RIVET

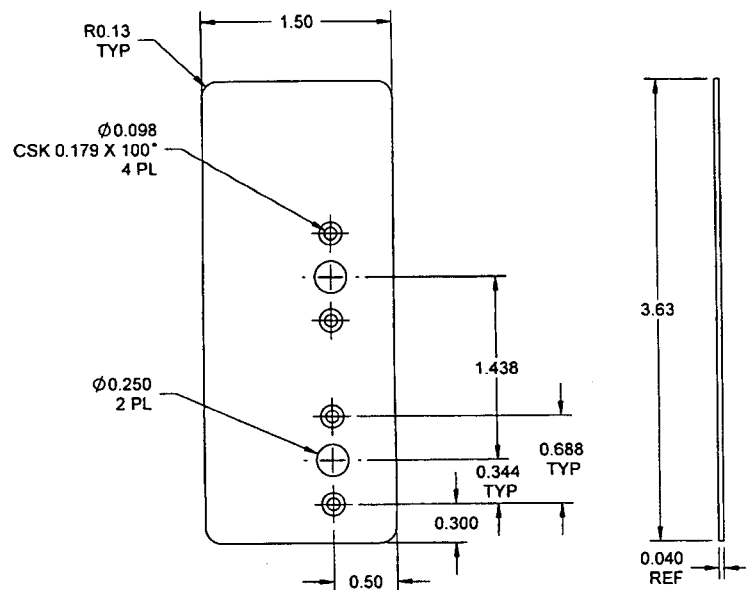


D3983-047 CLOSEOUT ATTACHMENT

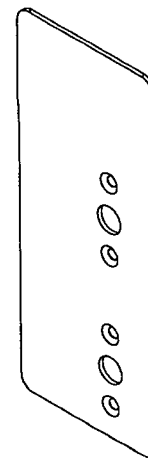
W/O 53154

NOTES:
 MATERIAL: SEE BOM
 FINISH: N/A
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 UNITS: INCHES UNLESS OTHERWISE NOTED
 BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-047" AND B/N USING FINE POINT PERMANENT INK MARKER
 WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 5 OF 7
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W/053156

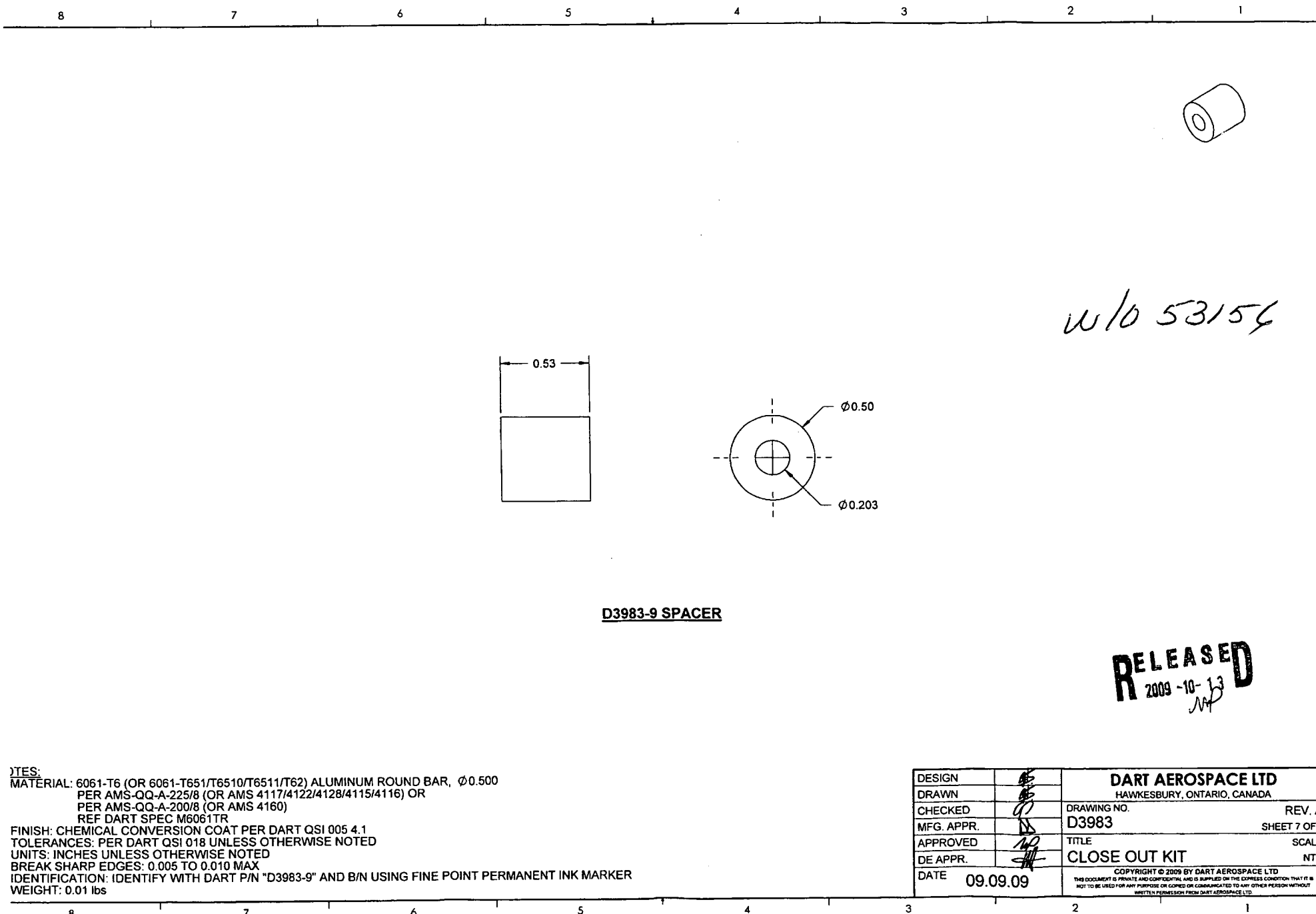


D3983-7 PLATE

RELEASED
2009-10-13
MP

NOTES:
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		CLOSE OUT KIT	NTS
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D3983-9 SPACER

RELEASED
2009-10-13
MP

NOTES:
MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR, $\varnothing 0.500$
PER AMS-QQ-A-225/8 (OR AMS 4117/4122/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061TR
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-9" AND B/N USING FINE POINT PERMANENT INK MARKER
WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 7 OF 7
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